

**Work Order ID 115122**

Monday, March 17, 2014 2:46:32 PM

**\*115122\***

Page 1

Item ID: D3537-3

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Wearpad

Start Date: 3/17/14 Start Qty: 20.00 **\*20\***

Cust Item ID:

Required Date: 3/17/14 Req'd Qty: 20.00 **\*20\***

Customer:

Reference:

Approvals: Process Plan: MLO Date: 14-03-19  
QC: \_\_\_\_\_ Date: \_\_\_\_\_Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

100

**\*100\***

FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

304-0631-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-  
Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

**\*110\***

QC

Quality Control

Memo

120

QC8- Inspect parts - second check

**\*120\***

QC

Quality Control

Memo

DAS  
27  
9.89  
M 3/3124 0 14-03-3124 0 14-03-31

24

DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: \_\_\_\_\_  
 Part No. \_\_\_\_\_  
 NCR No. \_\_\_\_\_

### DISPOSITION

Rework   
 Scrap   
 Use-as-is   
 Suspected Unapproved

### AGAINST DEPARTMENT/PROCESS

Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear	General							
	<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced			
	<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up			
	<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure			
	<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld			
	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled			
	<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other			
	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge				
	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread					
	<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set					
	<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration					
	<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence					

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**\*115122\***

Page 2

Item ID: D3537-3

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Wearpad

Start Date: 3/17/14 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 3/17/14 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start

**\*NR1\***

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

**\*130\***

NC BRAKE

0.00

24X

DAS  
36  
9.89

Brake NC

Memo

Brake NC

Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158

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DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____	<b>DISPOSITION</b>			<b>AGAINST DEPARTMENT/PROCESS</b>					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									
<b>FAULT CATEGORY</b>									
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b>		<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function  <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence			
				<b>General</b>					
				<b>General</b>					
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DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only 

Work Order: _____				<b>DISPOSITION</b>		<b>AGAINST DEPARTMENT/PROCESS</b>					
Part No. _____				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
				Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced							
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up							
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure							
Crimp/Kink/Ripple/Wave	Burr	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld							
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled							
Crushing	Countersink	Misaligned/off center	Positioned Wrong								
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other							
Inspection Strip in Tube	Drawing	Misread									
Marks/Chatter	Drill Holes	Off-set									
Turning Sequence	Finish	Out of Calibration									
Wave/Twist in Tube	Fit/Function	Out of Sequence									

**Work Order ID 115122**

Monday, March 17, 2014 2:46:32 PM

**\*115122\***

Page 4

Item ID: D3537-3

Revision ID:

Item Name: Wearpad

Start Date: 3/17/14 Start Qty: 20.00

**\*20\***

Required Date: 3/17/14 Req'd Qty: 20.00

**\*20\***

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
Description

190

QC3- Inspect Part Finish

**\*190\***

QC

Quality Control

Memo

Set Up/  
Run Hours0.00 27  
9.83

0.00 44/11

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

Identify as per dwg & Stock Location: FP-001**\*200\***

Packaging

Packaging

Memo

0.00

0.00

210

QC21- Final Inspection - Work Order Release

0.00

0.00

**\*210\***

QC

Quality Control

Memo

X24 4/11/14 14/04/14MLJ 14-04-14AD 14-04-11

DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____				<b>DISPOSITION</b>		<b>AGAINST DEPARTMENT/PROCESS</b>																																																																																											
Part No. _____				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>																																																																																									
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Landing Gear				<table border="0" style="width: 100%; border-collapse: collapse;"> <tr> <td colspan="2" style="width: 25%; vertical-align: top; padding: 5px;">General</td> <td colspan="2" style="width: 25%; vertical-align: top; padding: 5px;">Folio/Program</td> <td colspan="2" style="width: 25%; vertical-align: top; padding: 5px;">Outside Dimensions</td> <td colspan="2" style="width: 25%; vertical-align: top; padding: 5px;">Pressure/Forced</td> </tr> <tr> <td style="vertical-align: top;"><input type="checkbox"/> Bending</td> <td style="vertical-align: top;"><input type="checkbox"/> Bend</td> <td style="vertical-align: top;"><input type="checkbox"/> Grain</td> <td style="vertical-align: top;"><input type="checkbox"/> Over/Under tolerance</td> <td style="vertical-align: top;"><input type="checkbox"/> Set-up</td> </tr> <tr> <td style="vertical-align: top;"><input type="checkbox"/> Centre Not Concentric</td> <td style="vertical-align: top;"><input type="checkbox"/> BOM/Route</td> <td style="vertical-align: top;"><input type="checkbox"/> Hardware</td> <td style="vertical-align: top;"><input type="checkbox"/> Part Incorrect</td> <td style="vertical-align: top;"><input type="checkbox"/> Temperature/Cure</td> </tr> <tr> <td style="vertical-align: top;"><input type="checkbox"/> Cracks</td> <td style="vertical-align: top;"><input type="checkbox"/> Broken/Damage/Defect</td> <td style="vertical-align: top;"><input type="checkbox"/> Inspection Incomplete/Unqualified</td> <td style="vertical-align: top;"><input type="checkbox"/> Part Lost/Missing</td> <td style="vertical-align: top;"><input type="checkbox"/> Weld</td> </tr> <tr> <td style="vertical-align: top;"><input type="checkbox"/> Crimp/Kink/Ripple/Wave</td> <td style="vertical-align: top;"><input type="checkbox"/> Burrs</td> <td style="vertical-align: top;"><input type="checkbox"/> Instructions Incomplete/Unclear</td> <td style="vertical-align: top;"><input type="checkbox"/> Part Moved</td> <td style="vertical-align: top;"><input type="checkbox"/> Wrong Stock Pulled</td> </tr> <tr> <td style="vertical-align: top;"><input type="checkbox"/> Cuffs</td> <td style="vertical-align: top;"><input type="checkbox"/> Contamination</td> <td style="vertical-align: top;"><input type="checkbox"/> Misaligned/off center</td> <td style="vertical-align: top;"><input type="checkbox"/> Positioned Wrong</td> <td colspan="2" style="vertical-align: top; height: 40px;"></td> </tr> <tr> <td style="vertical-align: top;"><input type="checkbox"/> Crushing</td> <td style="vertical-align: top;"><input type="checkbox"/> Countersink</td> <td style="vertical-align: top;"><input type="checkbox"/> Mislabeled</td> <td style="vertical-align: top;"><input type="checkbox"/> Power Loss/Surge</td> <td colspan="3" style="vertical-align: top; height: 40px;"></td> </tr> <tr> <td style="vertical-align: top;"><input type="checkbox"/> Heat Treat</td> <td style="vertical-align: top;"><input type="checkbox"/> Cut Too Short</td> <td style="vertical-align: top;"><input type="checkbox"/> Misread</td> <td colspan="4" style="vertical-align: top; height: 40px;"></td> </tr> <tr> <td style="vertical-align: top;"><input type="checkbox"/> Inspection Strip in Tube</td> <td style="vertical-align: top;"><input type="checkbox"/> Drawing</td> <td style="vertical-align: top;"><input type="checkbox"/> Off-set</td> <td colspan="5" style="vertical-align: top; height: 40px;"></td> </tr> <tr> <td style="vertical-align: top;"><input type="checkbox"/> Marks/Chatter</td> <td style="vertical-align: top;"><input type="checkbox"/> Drill Holes</td> <td style="vertical-align: top;"><input type="checkbox"/> Out of Calibration</td> <td colspan="6" style="vertical-align: top; height: 40px;"></td> </tr> <tr> <td style="vertical-align: top;"><input type="checkbox"/> Turning Sequence</td> <td style="vertical-align: top;"><input type="checkbox"/> Finish</td> <td style="vertical-align: top;"><input type="checkbox"/> Out of Sequence</td> <td colspan="7" style="vertical-align: top; height: 40px;"></td> </tr> <tr> <td style="vertical-align: top;"><input type="checkbox"/> Wave/Twist in Tube</td> <td style="vertical-align: top;"><input type="checkbox"/> Fit/Function</td> <td colspan="9"></td> </tr> </table>								General		Folio/Program		Outside Dimensions		Pressure/Forced		<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up	<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure	<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld	<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong			<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge				<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread					<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Off-set						<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Out of Calibration							<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence								<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function									
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<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function																																																																																																

# Picklist Print

Monday, March 17, 2014 2:46:31 PM

Page 1

Work Order ID: 115122

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Parent Item: D3537-3

\*D3537-3\*

Parent Item Name: Wearpad

Start Date: 3/17/14

Required Date: 3/17/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	274.8270	0.149	4	**		

\*M304S16GA\*

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	274.827	
M126915	1.487	
M127821	126.13	
M128054	34.04	
M128423	113.17	128423

3/17/14-03-31

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

### Work Order update only

DART AEROSPACE LTD	Work Order:	115122
Description: Wearpad	Part Number:	D3537-3
Inspection Dwg: D3537	Rev: C	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

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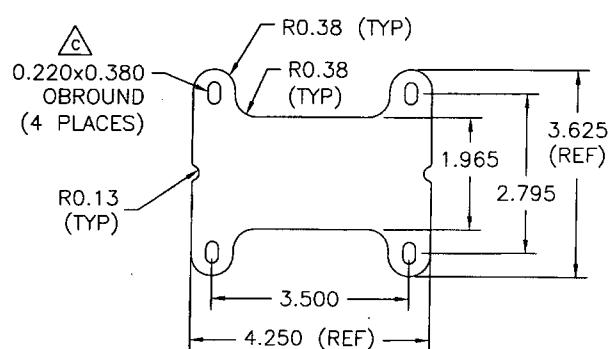
27

Measured by:	Jay	Audited by:	959	Prototype Approval:	N/A
Date:	14-03-31	Date:	14/3/21	Date:	N/A

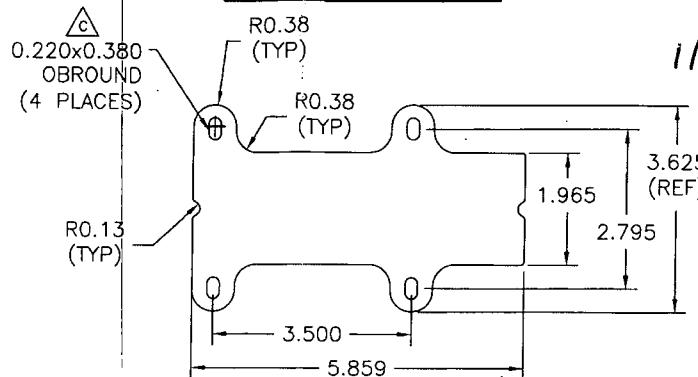
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E



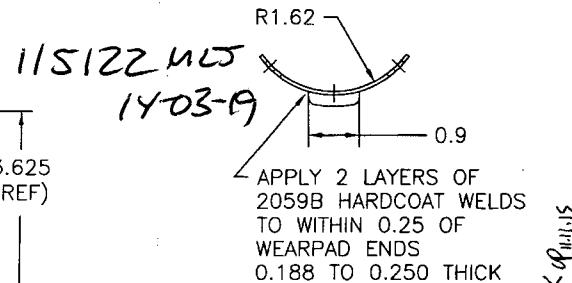
### D3537-1F FLAT PATTERN



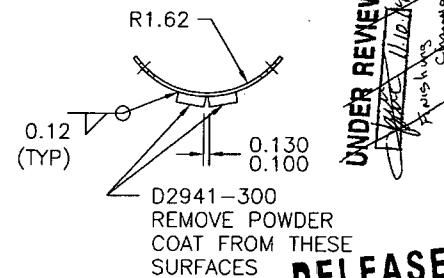
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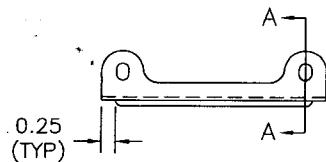
### SECTION A-A



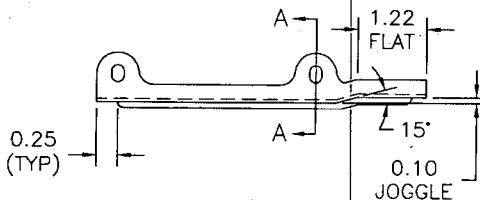
### SECTION B-B



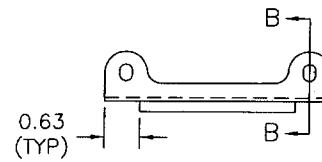
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DATE	APPROVED	DRAWING NO. D3537 REV. C SHEET 1 OF 1
07.04.13	4	WEARPAD SCALE 1:2